

Work Order ID 86193

86193

June-22-12 1:55:32 PM

Item ID: D2171

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Clamp

Stop ***NS2***

Start Date: 22/06/2012 Start Qty: 20.00

20

Cust Item ID:

Required Date: 06/07/2012 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12/06/22 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2171

Rev D

84

100

0.00

100

PURCHASING

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: B

Prog Rev: D

304.063"

2-Deburr if necessary

1312-7-5

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

1312-7-5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				<i>counts</i> <i>834</i>			
130 *130* Brake NC Brake NC	Form as per dwg Small Fab Memo 1 - remove press and machine marking as necessary	0.00 0.00				<i>34</i>			<i>SB</i> <i>12/07/09</i>
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				<i>counts</i> <i>834</i>			

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Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Identify as per dwg & Stock Location: US7

0.00

150

Packaging

Memo

0.00

Packaging

(34) 12/7/10sf

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

CK 12/7/10

ME 12-07-10

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Picklist Print

June-22-12 1:55:36 PM

Page 1

Work Order ID: 86193

86193

Parent Item: D2171

D2171

Parent Item Name: Clamp

Start Date: 22/06/2012

Required Date: 06/07/2012

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP REV:A 11.04.26 now made in house DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased		No		100	sf	1.5746	0.0258	0.543158	1.		

M304S16GA

304/316 Sheet .063

**

B12-7-5

Location

Loc Qty

Loc Code

MAT020

1.574633

121889

1.574633

122245

34

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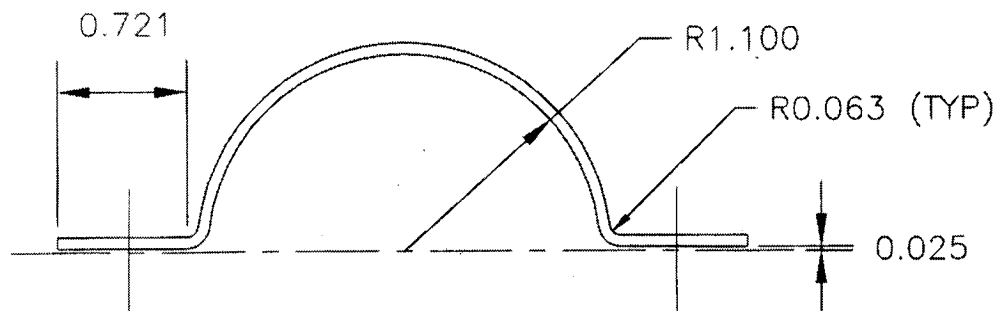
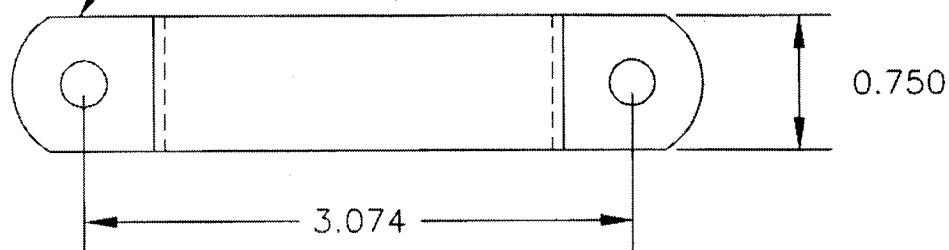
NOTE: Date & initial all entries



DESIGN BW	DRAWN BY DA	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED KE	DRAWING NO. D2171	REV. D SHEET 1 OF 1
DATE 99.03.08	TITLE CLAMP		SCALE 1:1
B	96.01.29	REDRAWN	
C	97.05.14	RADIUS CHANGED, CUSHION ADDED	
D	99.03.08	REMOVE CUSHION (TSR A890) 4.158 WAS 4.888	

RELEASED
99.03.11 KE

PUNCH ENDS PER SPEC
CONTROL DRAWING D2727



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 86193 M/C

12/06/22

MATERIAL: 304/316 SS 0.063 THICK
FLAT LENGTH: 4.968 END-END
4.158 HOLE-HOLE



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